

TAPERED LEADER PIN SETS

POSITIONING PINS FOR INSERT MOLDING

Ⓜ Non JIS material definition is listed on P.1351 - 1352

RoHS **TGPS**

① Leader Bushing
 M SUJ2
 H 58~60HRC
 ② Guide pin
 M SUJ2
 H 58~60HRC
 ③ Spacers
 M S45C
 H 38~43HRC
 S Black Oxide (Fe3O4)

D ₁	D ₂	D ₃	A	H	T	M	l ₁	H ₁	l ₂	T ₁	d ₁	d ₂	t ₁	Part Number		L					
														Type	D						
14	8	9.8	12.4	16	4	4	8	14	8	4.5	4.4	7.6	4.5	TGPS	10	20 25					
18	10	11.6	17	20	4	5	8	16	8	4	6	9	5.5		12	20 25 30					
25	14	15.9	21	30	6	8	15	20	14	5	8.2	13.5	8.2		16	20 25 30 35 40 50 60					
30	18	19.1	26	35	8										24	6	8.5	14	9	20	25 30 35 40 50 60
35	23	24.1	30	40	8										30	6	8.5	14	9	25	30 40 50 60

Ⓜ TGPS16—20 → l₁=10, M8×10

Order **Part Number** — **L**
 TGPS16 — 40

Price **Quotation**

Days to Ship **Quotation**

Characteristics

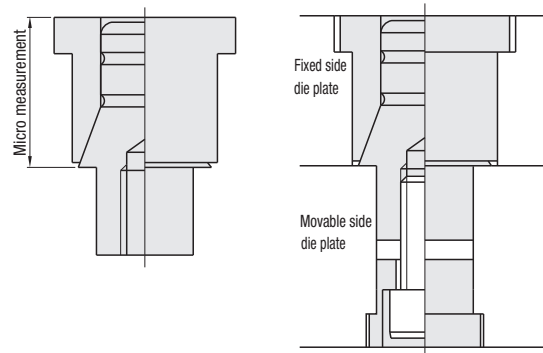
It has the positioning functions of Leader Pin/Leader Bushing/Tapered Pin Sets. It saves space and functions in positioning itself with the tapered section.

When using

A set of a pin, bushing and spacer. Make sure to use the pin and bushing in this combination.

How to Mount the Tapered Leader Pin Set

1. Create a hole for the leader pin and bushing in about ± 0.01 tolerance.
2. Set the leader pin and bushing in slightly tight, and measure the distance between the top of the bushing and the bottom of the pin's tapered flange using a micrometer. (Right drawing)
3. Finish the fixed die plate with a tolerance of $-0.01 \sim -0.03$ of the value obtained in 2, above.
4. Press fit the leader bushing into the fixed die plate.
5. Set the leader pin on the movable die plate and hold it by attaching the spacer from the rear and fastening it with a bolt.
6. Set the die plates on a molding machine and close them. This should make the leader pin's flange slightly bite into the die plate and completely align it with the bushing.



RoHS **PPI** (Tip tapered type)

PPIR (Tip R type)

*P0.80~1.49 → G=10°
 *ℓ = √(P(10-P/4))

SKH51
 H 58~60HRC

H	Part Number		L	P	G°	U/Price				
	Type	No.				0.1mm increments	0.01mm increments	1~4 pcs.	5~19	20~49
4	PPI PPIR	2	10.0~40.0	0.80~1.49 1.50~1.99	10	Quotation				
5		2.5								1.50~2.49
6		3								2.00~2.99
7		4								3.00~3.99

Order **Part Number** — **L** — **P** — **G** — (No rounding)
 PPI 3 — 20.0 — P2.60 — G15 — R0
 PPIR2.5 — 18.0 — P2.00

Days to Ship **Quotation**

Alterations **Part Number** — **L** — **P** — **G** — (LKC · PKC · KC · etc.)
 PPI3 — 20.00 — P2.60 — G15 — LKC

ex Example Use for hoop positioning in insert molding process.

Alterations	Code	Spec.	1Code
	LKC	Changes the tolerance. L +0.1 → +0.05 When using LKC, L dimension can be designated in 0.01mm increments.	Quotation
	PKC	Changes shaft diameter tolerance [Designation method] PKC P -0.01 → -0.005	
	KC	KC=0.1mm increments KC=P/2 → 0.005mm increments possible When KC=P/2 KC -0.1 → -0.02 Ⓜ P/2 ≤ KC < H/2	
	WKC	WKC=0.1mm increments WKC=P/2 → 0.005mm increments possible When WKC=P/2, WKC -0.1 → -0.02 Ⓜ P/2 ≤ WKC < H/2	
	HC	HC=0.1mm increments Ⓜ P ≤ HC < H Ⓜ In relation to the diameter tolerance, alteration may create a straight piece with little diameter difference between the head and shaft.	

